

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015141**Date Inspected:** 10-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Out Side

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 11BE , weld No. SSD18A-PP100-136. The welder is identified as #047772. ZPMC QC is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Bay#19

This QA Inspector observed the following work in progress:

FCAW in the 3F position for the OBG Bike Plate , weld No. BK004A6-009-115. The welder is identified as #208641. ZPMC QC is identified as Mr. Zhoe Chang . The welding variables recorded by QC appear to comply with WPS-B-T-2133.

FCAW in the 1G position for the OBG Bike Plate , weld No. BK004A1-008-008. The welder is identified as #062757. ZPMC QC is identified as Mr. Zhoe Chang . The welding variables recorded by QC appear to comply with WPS-B-T-2131-B-U2-F.

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Bay #16

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AW bottom Plate, weld No. BP3073-001-004. The welder is identified as #045270. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3c-S-2.

During the Quality Assurance (QA) random in-process visual inspection of Orthotropic Box Girder (OBG) segment 13AW Bottom plate at Bay#16, this QA inspector discovered that the base material was damaged on the Bottom plate due to carbon Arc back gouging. The affected bottom plates are identified as BP3075-001, BP3073-001 and BP3074-001. The material are A709 Grade 345 Non Seismic Performance Critical Member (Non SPCM). The QA inspector informed to ZPMC QC Mr. Li Ming Yang to submit weld repair report before repair the base metal of the bottom plates. OBG bottom plates are located in fabrication Bay 16.

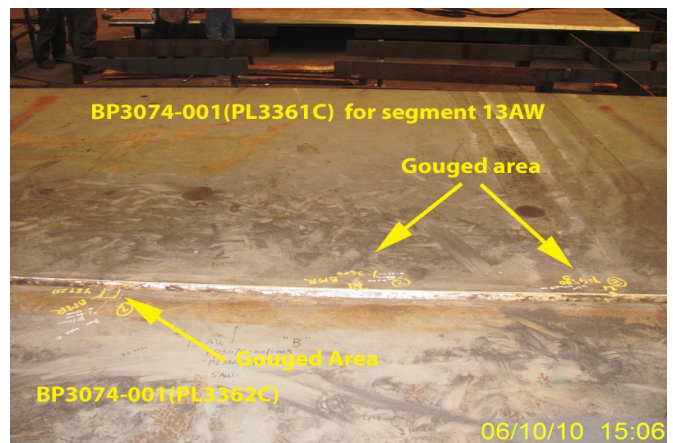
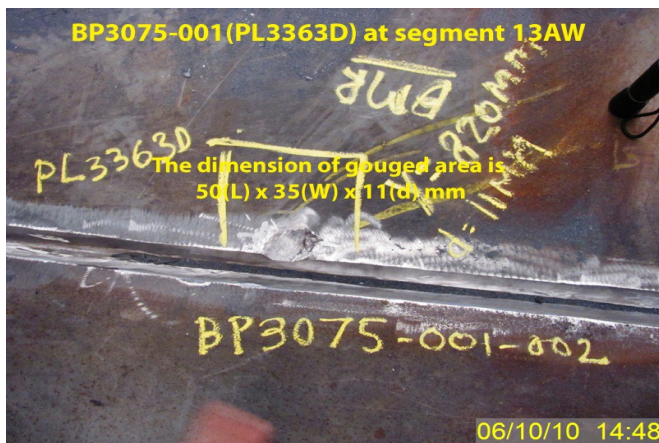
Magnetic Particle Testing (MPT) for Bike Path

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG Bike Path BK4A-003. This QA inspector generated a (MT) report for this date. This area was previously tested and accepted by ZPMC QC MT technicians.

The area designations reviewed are as follows:

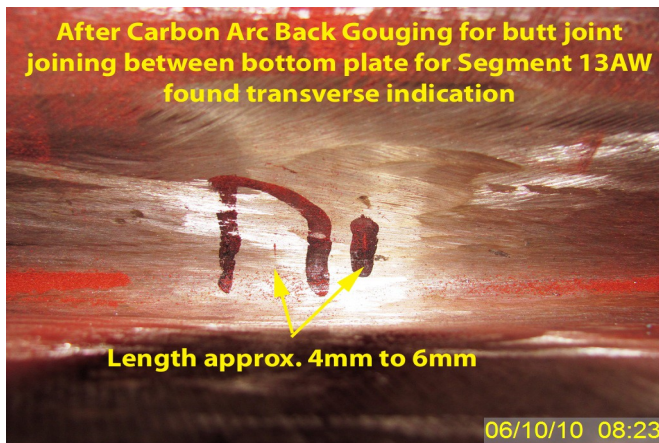
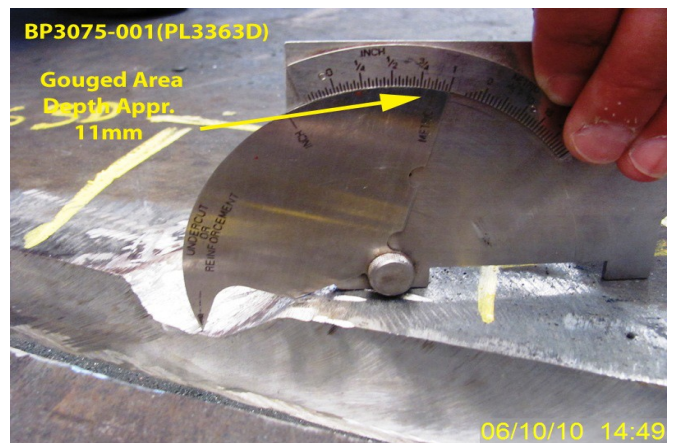
MT was performed on base metal repair locations and area affected by heat straightening on the top plate BKPL1A and BKPL2A of bike path BK4A-003.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer